



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D350-748-243TRN
Job Sheet 173677



Part No: D350-748-243TRN

Job Qty: 1 ea

Part Name: Crosstube Installation, High Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A IPP Rev: PRELIM New Issue LL 12.05.08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Crosstubes-1		PMP
100	Mori Seiki	1 pcs		4/17/18	2.01	3.57	Mori Seiki TL-40		PMP
110	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		PMP
120	Mori Seiki	1 pcs		4/17/18	0.00	3.57	Mori Seiki TL-40		PMP
130	QC	1 pcs		4/17/18	0.00	0.00	QC2-1		PMP
140	QC	1 pcs		4/17/18	0.00	0.00	QC8		
150	Crosstubes	1 pcs		4/18/18	0.00	0.81	Crosstubes-2		
190	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		
200	QC21-SA	1 Ea		4/18/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-241 on both ends. 3- Turn program 02000 Descriptions: section on both side as per folio FB468. 4- Turn program 03000 section on both side as per folio FB468.

120 - 1- Turn program 04000 section on both side as per folio FB468. 2- Turn program 05000 section on both side as per folio FB468. 3- Blend transition lines only with belt sander 60 grit 4-Scribe part # as per Dwg D350-748-243

130 - PERFORME ULTRASONIC MEASUREMENT

150 - 1-Grind machining marks

190 - Identify and stock in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6021-125	Crosstube Material - 17-4Ph SS	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6021-125	1	71	0

B127272

Part Specifications

Specifications could not be found.

Plex 3/6/18 12:37 PM Dart.Gagnon.Michelle



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Container No: S057962



Part: D350-748-243TRN

Job No: 173677

Serial No/Batch: S057962

Revision:

Inspector:

Date: 04/04/18

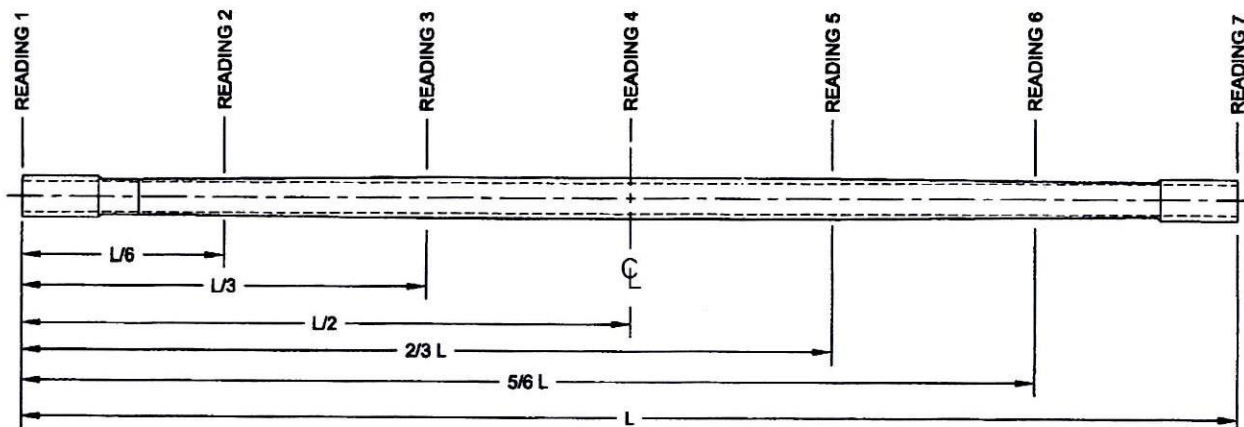
DART AEROSPACE LTD	Work Order:	173677
Description: Crosstube Assembly (AS350/355 High Aft SS)	Part Number:	D350-748-243
Inspection Dwg: D350-748-243 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+/-0.005	2.243	✓		VERN 08	
	2.180	+0.005/-0.000	2.185	✓		RLM 2"3"24	
	2.180	+0.005/-0.000	2.185	✓			
	2.208	+0.005/-0.000	2.2125	✓			
	2.234	+0.005/-0.000	2.239	✓			
	2.253	+0.005/-0.000	2.258	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.299	+0.005/-0.000	2.306	✓		RLM 2"3"24	
	0.063	+/-0.010	.063	✓		RL	
	5.25	+/-0.060	5.260	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RL	
	R0.50	+/-0.030	.50	✓		RL	
SIDE B	2.240	+/-0.005	2.243	✓		VERN 08	
	2.180	+0.005/-0.000	2.185	✓		RLM 2"3"24	
	2.180	+0.005/-0.000	2.185	✓			
	2.208	+0.005/-0.000	2.213	✓			
	2.234	+0.005/-0.000	2.239	✓			
	2.253	+0.005/-0.000	2.258	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.299	+0.005/-0.000	2.306	✓		RLM 2"3"24	
	0.063	+/-0.010	.063	✓		RL	
	5.25	+/-0.060	5.259	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RL	
	R0.50	+/-0.030	.50	✓		RL	
	124.70	+/-0.060	124.7	✓		TAPE	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	125	125	123	123	.002	0.030"
READING 2 L = 20.78	116	112	110	115	.006	
READING 3 L = 41.57	159	152	151	158	.008	
READING 4 L = 62.35	157	156	155	157	.002	
READING 5 L = 83.13	153	155	156	157	.004	
READING 6 L = 103.92	111	112	117	117	.006	
READING 7 L = 124.7	124	124	125	125	.001	

Calibration Result

Actual Block Thickness: 100 200

Sitiescan 250 Measured Thickness 100 200

Measured by:	<u>pmP</u>
Date:	<u>2018-04-04</u>

Audited by:	<u>JW</u>
Date:	<u>18-04-16</u>

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue (P/O D350-748-203)	KJ	<u>[Signature]</u>

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173677
MAR 06 2018

